

Work Order ID 128275

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Item ID: D4436-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Outboard Bracket Assembly
Start Date: 1/13/2015 Start Qty: 5.00 ***5*** Cust Item ID:
Required Date: 1/20/2015 Req'd Qty: 5.00 ***5*** Customer:
Reference:

Approvals: Process Plan: MLS Date: 15-01-14 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4436	A								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut D4436-1 as per Dwg								
6061.040~	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

(6)

DC 15/01/26

(6)

DC 15/01/26

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Item ID: D4436-043 Accept ***N900040100*** Setup Start ***NS1***
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Start Date: 1/13/2015 Start Qty: 5.00 ***5*** Cust Item ID:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							DAS 38 9-89
120									
QC	Memo	0.00							
Quality Control									JAN 27 2015
130	Bend as per dwg	0.00			DAS				
130					30				
Brake NC	Memo	0.00			9-89	6			15/01/28
Brake NC									
140		0.00							
140									
Small Fab	Memo	0.00							
Small Fab	C"SINK AS PER DWG								15/01/29 DAS 36 9-89

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 1/13/2015 **Start Qty:** 5.00 ***5***

Cust Item ID:

Required Date: 1/20/2015 **Req'd Qty:** 5.00 ***5***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** **Tooling:** **Date:**

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180

0.00

180

0.00

Small Fab

Memo

Small Fab

Assemble as per dwg, do not install rubber seal.

185

QC5- Inspect part completeness to step on W/O

0.00

185

0.00

OC

Memo

Quality Control

DAS
38
9-89

FFR 05 2015

190

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

190

0.00

Powdercoat

Memo

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:20

28

3.50

DAS 34 8.90

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Item Name: Aft Outboard Bracket Assembly
Start Date: 1/13/2015 Start Qty: 5.00 ***5*** Cust Item ID:
Required Date: 1/20/2015 Req'd Qty: 5.00 ***5*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location: <u>5T618</u>	0.00							
210									
Packaging	Memo	0.00				<u>6X</u>	<u>DAS</u> <u>28</u> <u>9-89</u>	<u>FEB 11 2015</u>	
Packaging									
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.00							
Quality Control									

MCS 1502-11

(Handwritten signature: MS 2-11)

Picklist Print

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Work Order ID: 128275

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Parent Item: D4436-043

D4436-043

Parent Item Name: Aft Outboard Bracket Assembly

Start Date: 1/13/2015

Required Date: 1/20/2015

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP revA 11.10.06 new issue EC verified by:DD
12.01.24 PER DWG REV.A DD VERF:EC

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.040

Purchased

No

100

sf

64.7501

1.59

9

M6061T6S 040

02/15/01/26

6061-T6 .040 Sheet

Location

Loc Qty

Loc Code

MAT021

64.7501

m130312

32

13.333

m130585

32.7501

MS20426AD3-2

Purchased

No

180

Each

18,153.00

4

20

MS20426AD3-2

FF

FEB 05 2015

Rivet

15/02/05

Location

Loc Qty

Loc Code

Mezz

18153

1173

8873

13276

9280

24

MS21075L08

Purchased

No

180

Each

172.0000

2

10

MS21075L 08

FF

FEB 05 2015

ANCHOR NUT

Location

Loc Qty

Loc Code

ST300

172

128199

M128635

172

20 12

Picklist Print

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Work Order ID: 128275

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Parent Item: D4436-043

D4436-043

Parent Item Name: Aft Outboard Bracket Assembly

Start Date: 1/13/2015

Required Date: 1/20/2015

Start Qty: 5.00

Required Qty: 5.00

D4441-1

Manufactured No

202 f

654.5000 1.408 8

D4441-1

Rubber Seal

**DAS
28
9-89**

FEB 10 2015

Location

Loc Qty

Loc Code

ST407

418

120932

418

ST422

236.5

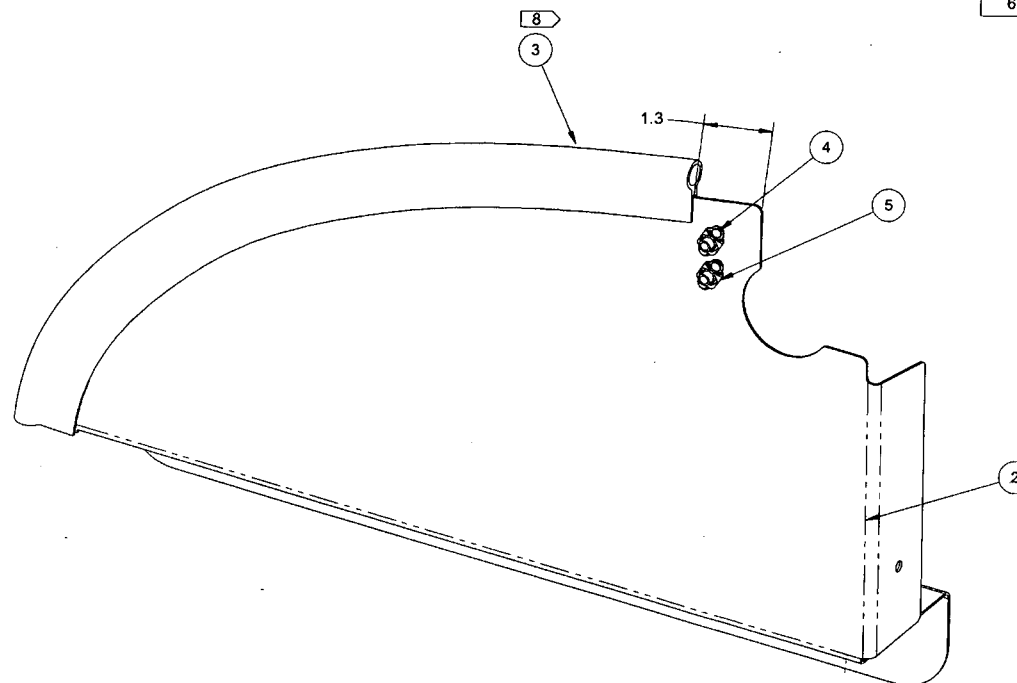
120932

236.5

9.6

cut qty 1 to 16.00"

ITEM	QTY -043	PART NUMBER	DESCRIPTION
1	X	D4436-043	AFT OUTBOARD BRACKET ASSEMBLY
2	1	D4436-1	BRACKET
3	1	D4441-1-160	RUBBER SEAL
4	4	MS20426AD3-2	RIVET
5	2	MS21075L08	NUT PLATE
6	A/R	3M 1300/1300L	ADHESIVE



D4436-043 AFT OUTBOARD BRACKET ASSEMBLY

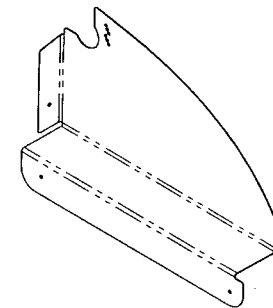
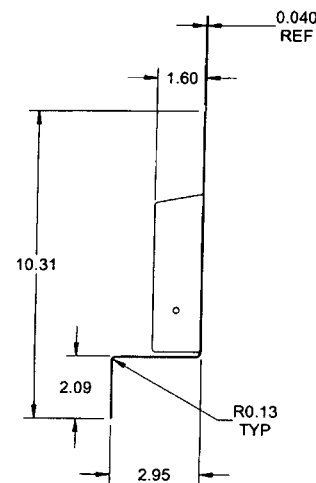
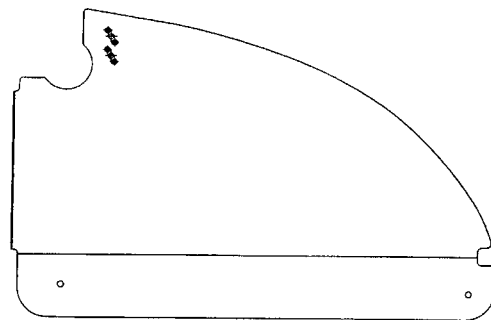
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDEXT" (4.3.5.7) PER DART QSI 005 4.3
MASK NUT PLATE HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.78 lbs
- 8) INSTALL RUBBER SEAL TO EDGE OF PART AFTER POWDER COAT USING 3M 1300/1300L ADHESIVE
ENSURE BRACKET IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL
IT IS ACCEPTABLE TO NOTCH THE SEAL AS REQUIRED TO PREVENT IT FROM BUCKLING

128275.MLS
150114

2012-01-23

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D4436	REV. A
MFG. APPR.	RF		SHEET 2 OF 7
APPROVED	RF	TITLE COVER ASSEMBLY	SCALE NTS
DE APPR.	RF		
DATE	12.01.17	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



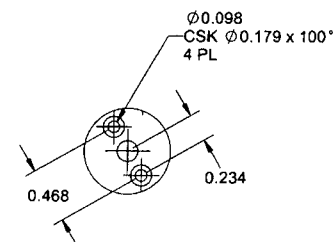
D4436-1 BRACKET

NOTES:

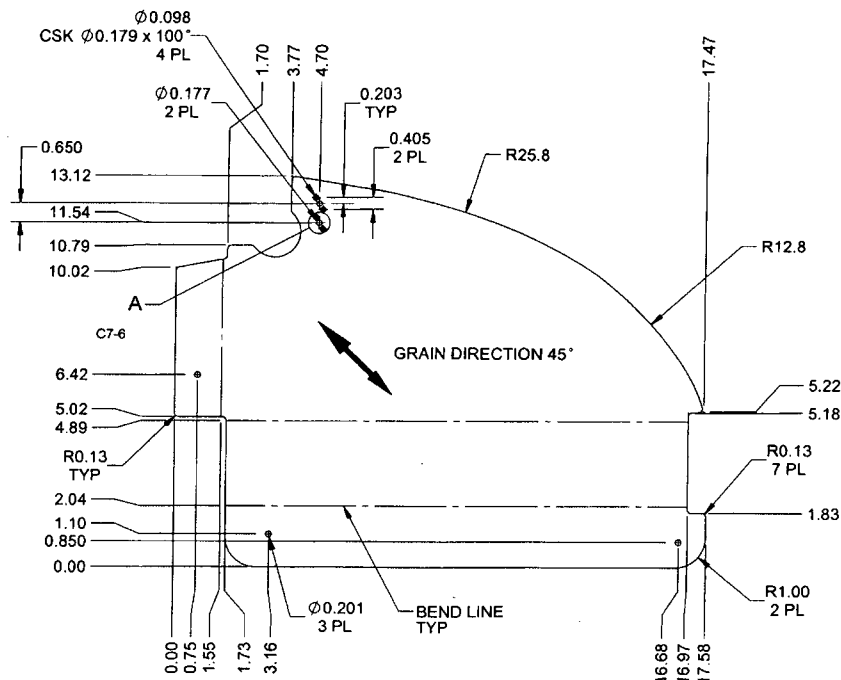
- 1) MATERIAL: MAKE FROM D4436-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.69 lbs

RELEASE
2012-07-23

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D4436	REV. A
MFG. APPR.	RF		SHEET 4 OF 7
APPROVED	RF	TITLE COVER ASSEMBLY	SCALE NTS
DE APPR.	RF	DATE 12.01.17	
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DETAIL A C6-6
SCALE 4X, TYP



D4436-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.69 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D4436	REV. A
MFG. APPR.	RF	SHEET 5 OF 7	
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	COVER ASSEMBLY	
DATE	12.01.17	NTS	

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